

CLAIMS

1. Packaging bag with a front wall (12) and a rear wall (14) made of a packaging film (16, 16a,b), in which the front wall (12) and the rear wall (14) are bonded together along a peripheral edge (18) and the front wall (12) and/or the rear wall (14) is printed on the outside of the bag, characterised in that on the outside of the bag the front wall (12) and/or the rear wall (14) is bonded to a cover film (20, 20a,b) which is printed on one or both sides, substantially the entire area of which is bonded to and peelable from the front wall (12) or rear wall (14).
2. Packaging bag according to claim 1, characterised in that the front wall (12) consists of a first packaging film (16a) and the rear wall (14) consists of a second packaging film (16b) and at least one of the packaging films (16a,b) is bonded to a cover film (20a,b).
3. Packaging bag according to claim 1, characterised in that the front wall (12) and the rear wall (14) are made of the same packaging film (16) folded and bonded to the cover film (20).
4. Packaging bag according to any of the claims 1 to 3, characterised in that the cover film (20, 20a,b) is permanently bonded to the packaging film (16, 16a,b) in an edge area (24, 24a,b).
5. Process for the manufacture of packaging bags (10) with a front wall (12) and a rear wall (14) made of a packaging film (16a,b), in which the front wall (12) and the rear wall (14) are bonded together along a peripheral edge (18), the front wall (12) and/or the rear wall (14) are printed on the outside of the bag and bonded on the outside of the bag to a cover film (20a) which is printed on one or both sides and

with substantially its entire area bonded to and peelable from the front wall (12) or rear wall (14), which process has the following steps:

- A. one or two-sided printing of a cover film web (40a),
 - B. coating of one side of the cover film web (40a) with a peelable plastic layer (28a),
 - C. joining the cover film web (40a) by way of the peelable plastic layer (28a) to the printed side of a first packaging film web (42a) to form a peelable bond,
 - D. joining the first packaging film web (42a) bonded to the cover film web (40a) to a second packaging film web (42b),
 - E. bonding of the first packaging film web (42a) with the second packaging film web (42b) along peripheral edges (18).
6. Process for the manufacture of packaging bags (10) with a front wall (12) and a rear wall (14) made of a packaging film (16a,b), in which the front wall (12) and the rear wall (14) are bonded together along a peripheral edge (18), the front wall (12) and/or the rear wall (14) are printed on the outside of the bag and bonded on the outside of the bag to a cover film (20a) which is printed on one or both sides and with substantially its entire area bonded to and peelable from the front wall (12) or rear wall (14), which process has the following steps:
- A. one or two-sided printing of the first cover film web (40a),
 - B. coating of one side of the first cover film web (40a) with a first peelable plastic coating (28a),
 - C. joining the first cover film web (40a) by way of the first peelable plastic coating (28a) to the printed side of a first packaging film web (42a) to form a peelable bond,
 - D. one or two-sided printing of a second cover film web (40b),

- E. coating of one side of the second cover film web (40b) with a second peelable plastic coating (28b),
 - F. joining the second cover film web (40b) by way of the second peelable plastic coating (28b) with the printed side of a second packaging film web (42b) to form a peelable bond,
 - G. joining the first packaging film web (42a) bonded to the first cover film web (40a) to the second packaging film web (42b) bonded to the second cover film web (40b),
 - H. bonding the first packaging film web (42a) to the second packaging film web (42b) along the peripheral edges (18).
7. Process for the manufacture of packaging bags (10) with a front wall (12) and a rear wall (14) made of a packaging film (16a,b), in which the front wall (12) and the rear wall (14) are bonded together along a peripheral edge (18), the front wall (12) and/or the rear wall (14) are printed on the outside of the bag and bonded on the outside of the bag to a cover film (20a) which is printed on one or both sides and with substantially its entire area bonded to and peelable from the front wall (12) or rear wall (14), which process has the following steps:
- A. one or two-sided printing of a cover film web (40),
 - B. coating of one side of the cover film web (40) with a peelable plastic coating (28),
 - C. joining the cover film web (40) by way of the peelable plastic coating (28) with the printed side of a packaging film web (42) to form a peelable bond,
 - D. folding the packaging film web (42) bonded to the cover film web (40) in the web feed direction,
 - E. bonding the folded packaging film web (42) to itself along the peripheral edges (18).
8. Process according to one of the claims 5 to 7, characterised

in that the side of the cover film web (40, 40a,b) coated with the peelable plastic layer (28, 28a,b) is also coated with a permanent adhesive (24, 24a,b) in a pattern such that the permanent adhesive is located in the edge area of the bag.

9. Process according to claim 8, characterised in that all printing of the cover film webs (40 40a,b) and the packaging film webs (42, 42a,b) and the application of the permanent adhesive pattern (24, 24a,b) are performed using the register printing process.